



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3
Job Sheet 168401



Part No: D4776-3

Job Qty: 12 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/29/17	0.00	0.00	Start Up Machining		
100	Bandsaw	12 pcs		11/29/17	0.00	0.22	Bandsaw1		
110	CNC Vertical Machining	12 pcs		11/29/17	0.26	10.43	HAAS 1		
120	QC	12 pcs		11/29/17	0.00	0.00	QC2		
130	QC	12 pcs		11/29/17	0.00	0.00	QC8		
140	HandFinish	12 pcs		11/29/17	0.00	0.32	HandFinish1		
150	QC	12 pcs		11/29/17	0.00	0.00	QC7		
160	Powdercoat	12 pcs		11/30/17	0.00	0.15	Powdercoat1		
170	QC	12 pcs		11/30/17	0.00	0.00	QC3		
180	Packaging	12 pcs		11/30/17	0.00	0.00	Packaging3		
190	QC21-SA	12 Ea		11/30/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME:

9.25 OUT. 320° FINISH: 9.55.

M 138467.

DEC 04 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.500X02.500	4	12	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

DISPOSITIONRework ☐Skidtube ☐**AGAINST DEPARTMENT/PROCESS**

Part No. _____

NCR No. _____

Date : _____

5012238

**Skidtube Clevis**

PART NO: D4776-3
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/21/17
Job No: 168401

Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

Engineering ☐
 Quality ☐
 Other ☐

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval**Root**

Environment ☐	Operator ☐	Pressure/forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Offset/Setup ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Supplier ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Training ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Use for Testing ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Poor Information ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Rushing ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Product Improvement ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Process Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Manufacturing Process ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Past Due ☐	OTHER : ☐			
Misidentified ☐					

8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970	
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470	
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520	
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140	
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678	
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803	
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115	
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350	
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720	
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius

Plex 11/14/17 10:05 AM dart.poulin.mario

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